Thursday, 6/21/2007 2:28:37 PM

User

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

Drawing Name

:. SADDLE FITTING, FWD (OUTBOARD/INBOARD)

: 33041

Estimate Number P.O. Number

: 10531

NA : 6/21/2007

Part Number Drawing Number : D2572

This Issue Prsht Rev. First Issue

: NC, NA

Type : MACHINED PARTS Project Number **Drawing Revision**

: D2572 REV E ; N/A

: 32166 Previous Run

Material **Due Date** 7/11/2007

12 Um:

Each

Written By

Checked & Approved By

Comment

Re-format; Change to Dwg Rev. D & : Est: 1 02.10.02

incorporated D2572 KJ

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D6101005

7075-T7351 8.25X5.0X2.5



Comment: Qty.:

1.0000 Each(s)/Unit

12.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2572

Ensure that grain is along 5.00" length

Batch No:

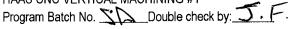
HAAS CNC VERTICAL MACHINING #1



2.0

HAAS1

Comment: HAAS CNC VERTICAL MACHINING #1



Total:

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove shap edges.

07.01.10

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572



4.0

INSPECT PARTS AS THE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE



Da	art	A	er	os	рa	ce	Ltd
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WORK ORDER CHANGES						
STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	STEP					STEP PROCEDURE CHANGE By Date Qty Chief Eng /

Part No: _	*	_ PAR #:	Fault Category:	NCR: Yes No DQA:	Date: 07/07/2
				QA: N/C Closed:	Date:

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Annaval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
							<u>.</u>	
,								
		,						

NOTE: Date & initial all entries

Thursday, 6/21/2007 2:28:37 PM Date: User: Kim Johnston **Process Sheet** Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD) Customer: CU-DAR001 Dart Helicopters Services Job Number: 33041 Part Number: D2572 Job Number: Description: Seq. #: **Machine Or Operation:** SECOND CHECK 5.0 QC8 Comment: SECOND CHECK HAND FINISHING1 6.0 HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 7.0 POWDER COATING POWDER COATING Comment: POWDER COATING Powder Coat GREEN SANDTEX (Ref: 4.3.5.1) as per QSI 005 4.3 Comment: INSPECT POWDER COAT 9.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 10.0 QC21 01.07.19 Comment: FINAL INSPECTION/W/O RELEASE Job Completion A AMPIA

Dart A	ero	azc	ace	Ltd
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W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	В	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
		·									
		•					-				
		•		-							
				•	,						
Part No	'	PAR #: Fault Category:		es No DG	L	Date:	<u> </u>				

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C C	losed:	Date:

NCR:	ICR: WORK ORDER NON-CONFORMANCE (NCF							
		Description of NC		Corrective Action Section B		Verification	A	T
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
•								
			·					,
, š								

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33041
,		
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Re	corded Actu	ıal Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.438	0.443	DT8682	0.446	0.439	0,439	0.439		
В	1.745	1.755		1.749	1.749	1,749	1.749		
С	3.495	3.505		3500	3.500	3,506	3.500		
D	1.745	1.755		1.7-49	1.749	1.749	1,749		
E	7.990	8.010		7.998	7.997	8.000	7,999		
F	0.490	0.510		0.500	0.507	0,502	0.503		
G	0.257	0.262	D78683 ~	0.258	0.258	0,258	0258		
Н	0.375	0.380	DT6084	0.377	0.377	0.377	6.377		
ı	0.490	0.510		0.504	1.497	0.498	0,500		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		0.569	0.567	0,567	0.569		
L	1.174	1.184		1.178	1.178	1.178	1.178		
М	1.490	1.500		1.494	1.494	1.494	1.494		
N	2.495	2.505		2,499	2.500	2.499	2.500		
0	3.869	3.879		3.872	3.871	3.872	3.872		
Р	0.115	0.135		0.123	0.124	0.124	0.124		
Q	0.115	0.135		0035	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.257	0.251	0.257		
S	0.115	0.135		0.135	0.131	0.132	0./32		
Т	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.961	2.961	2.96.1		
V	0.230	0.250		0.249	0.240	0.241	0.242		
W	0.115	0.135		0.130	0.132	0.131	0.130		
Х	0.307	0.312		0.310	0.310	0310	0.3/6		
Υ .	0.760	0.765		0.760	0.766	0.766	6760		
Z	0.352	0.372		0.358	0.362	0.360	0.363		
AA	0.470	0.530		0,506	0.500	0.506	0.500		
AB	0.615	0.635		0.636	0.630	0.630	0.636		
AC	0.053	0.073		0.063	0.063	0.063	0.0%3		
AD	0.240	0.260		0.257	0.248	0.747	0248		
AE	1.375	1.395		1. 383	1.386	1,385	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.262	0,260	0.260	0.260		
AH	0.240	0.260		0.257	0.251	0.252	0.253		
Al	2.000	2.020		2.000	2.002	2.004	2.003		
AJ	0.023	0.043		0.033	0.037	0.033	6.033		
	Acc	cept/Reje	ct						

			. 1	_\$Q
Measured by:	Jul.	Audited by	J.L.	
Date:	07/07/09	Date:	07/07/13	

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension Al	KJ/RF	1
E	05.12.05	Added dimension AJ	KJ/JLM	
			, ()	

DART AEROSPACE LTD	Work Order:	33041	
Description: Saddle, Fwd Inboard	Part Number:	D2572	
Inspection Dwg: D2572 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

			······································	Recorded Actual Dimensions			No.		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.438	0.443	₽78 682	6.439	0.439	439	. 438		
В	1.745	1.755		1,749	1.749	1,750	1.749		
С	3.495	3.505		3.499	3.506	7,500	3.500		
D	1.745	1.755		1,749	1.749	1444	1.750		
E	7.990	8.010		8.000	7.998	8,007	8-202		
F	0.490	0.510		Ď.501_	0.500	. 499	493		
G	0.257	0.262	DT8683	0.258	1,258		0.258		A-1-100
Н	0.375	0.380	-DT868 4-	0.377		0,377			
l	0.490	0.510		0.500	0,500	B. 498	0.500		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		0.567	0.568	0.566	0.568		
L	1.174	1.184		1.17-8	1.178	1.178	1.178		
М	1.490	1.500		1.494	1. 494	1.494	1.494		
N	2.495	2.505		2,500	2.500	2,500	3,871		
0	₹3.869	3.879		3,872	3.872	3.872	3,871		
Р	0.115	0.135		0.124	0.124	0.124	0.124		
Q	0.115	0.135		0.135	0.135	0.135	8.135		
R	0.240	0.260		0.251	0.256	0,251	0.257		
S	0.115	0.135		0.136	0.132	0.132	8.131		
Т	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.961	2.961	2.961		
V	0.230	0.250		0.240	0.241	0.241	6.241		
W	0.115	0.135		0.126	0.130	130	, 125		
X	0.307	0.312		0.3/0	0.316	-31/	-311		
Υ	0.760	0.765		0.766	0.760	.762	-462		
Z	0.352	0.372		0.365	0.364	. 364	-364	'	
AA	0.470	0.530	, ,	0.500	0.500	0.500	0.500		
_AB	0.615	0.635		0.630	0.630	630	,631		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0,246	0.249	0.248	0.249		
AE	1.375	1.395		1.385	1,385	1.385	1.386		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.266	0.266	0.266	0.250		
AH/	0.240	0.260		0.249	0.251	0.257	0,257		
Al	2.000	2.020		2.001	2.003	3002	3.003		
AJ	0.023	0.043	<u> </u>	0.033	0.033	-033	.033		
	Ac	cept/Reje	ct						

Measured by:	and Isl	Audited by	7.1
Date:	07.01.10	Date:	04/07/13

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	·
В	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension Al	KJ/RF	1
E	05.12.05	Added dimension AJ	KJ/JLM	
			, ()	/ /

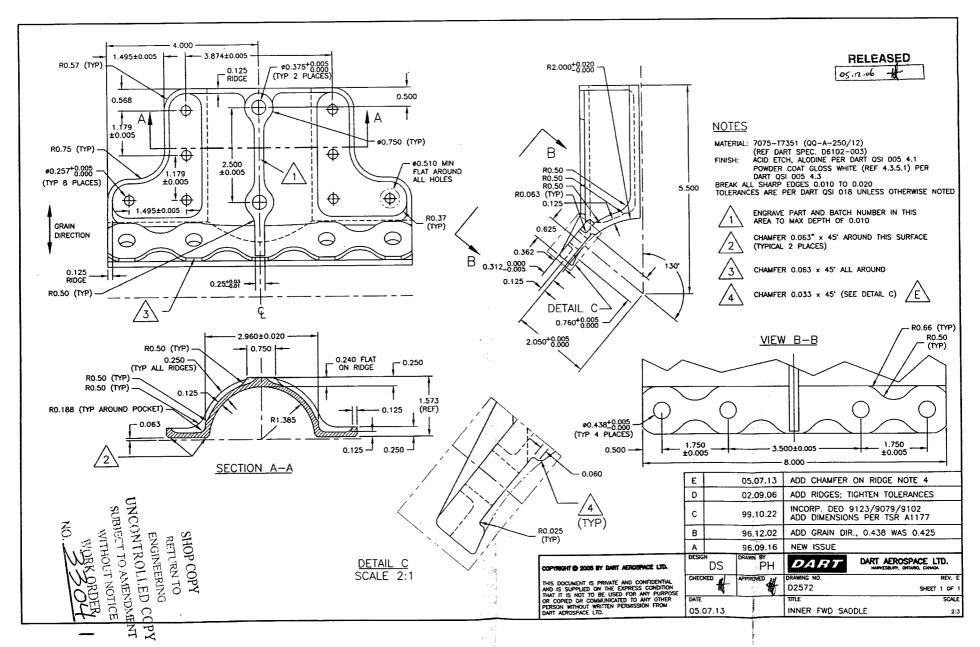
DART AEROSPACE LTD	Work Order:	33041
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim Min Max Go/No Go Gauge 1 2 3 4 By Date						Red	Recorded Actual Dimensions				
B 1.745 1.755		Dim	Min	Max		1		3	-	Ву	Date
C 3.495 3.505 7.506 3.507 3.757 3.601 D 1.745 1.755 7.750 7.307 7.507 7.507 F 7.990 8.010 8000 8000 3.502 7.502 7.507 F 0.490 0.510 7.502 800 3.503 7.503 7.507 G 0.257 0.262 875684 3.76 3.76 3.76 3.72 1 0.490 0.510 3.76 3.76 3.76 3.76 3.72 1 0.490 0.510 3.702 3.360 3.76 3.72 1 0.490 0.510 3.702 3.360 3.76 3.74 1.174 1.184 1.175 1.77 1.77 1.77 1.77 1.77 1.77 1.7		Α			DI8682			,437			
D 1.745 1.755 E 7.990 8.010 F 0.490 0.510 G 0.257 0.262 H 0.375 0.380							1,700				
E 7.990 8.010 F 0.490 0.510 F 0.490 0.590 F		С	3.495				3.500	3,75	3,501		
F 0.490 0.510 G 0.257 0.262 BF9663 2.5% 2.5% 2.5% 2.5% H 0.375 0.380 BF8664 3.76 3.76 3.76 J 1 0.490 0.510 502 503 3.76 3.76 J 1.174 1.184 1.175 1.77 1.77 1.77 K 0.558 0.578 L 1.174 1.184 1.174 1.184 1.175 1.77 1.77 1.77 M 1.490 1.500 1.715 1.72 1.73 1.77 1.77 N 2.495 2.505 2.418 2.47 2.77 2.77 2.47 2.47 0.38 0.3869 3.879 P 0.115 0.135 1.24 1.24 1.25 1.25 1.25 1.25 1.25 1.25 1.25 1.25		D							1750		
G 0.257 0.262 BEBSS 2.5		E	7.990	8.010		8,003		7.895			
H 0.375 0.380 -DT8684 376 376 376 376 376 376 376 376 376 376 376 376 376 376 376 376 377		F	0.490			,502	-000°	. 258	.495		
1 0.490 0.510		G				258		-258			
J 1.174 1.184 1.775 1.775 1.755	•	Н	0.375		DT&684	376	-346	. 376			
K 0.558 0.578	312	1	0.490			502	.503	-500	-803		
L 1.174 1.184		J	1.174			1.179	6175	1.179	6177		
M 1.490 1.500	.439	K	0.558			571		.570	.571		
N 2.495 2.505 2.478 2.477 2.777 2.778 O 3.869 3.879 3.874 3.884 <td>,</td> <td>L</td> <td>1.174</td> <td></td> <td></td> <td>1.179</td> <td>• /</td> <td>1.177</td> <td></td> <td></td> <td></td>	,	L	1.174			1.179	• /	1.177			
O 3.869 3.879 P 0.115 0.135 Q 0.115 0.135 R 0.240 0.260 S 0.115 0.135 T 0.178 0.198 U 2.940 2.980 V 0.230 0.250 V 0.115 0.135 X 0.307 0.312 X 0.307 0.312 X 0.365 AA 0.470 0.530 AB 0.615 0.635 AC 0.053 0.073 AD 0.240 0.260 AB 0.240 0.260		M		1.500		1.485_		1. YS\$			
P 0.115 0.135	2.124	N	2.495			24%				,	
Q 0.115 0.135 R 0.240 0.260 S 0.115 0.135 T 0.178 0.198 U 2.940 2.980 V 0.230 0.250 W 0.115 0.135 X 0.307 0.312 Y 0.760 0.765 Z 0.352 0.372 AA 0.470 0.530 AB 0.615 0.635 AC 0.053 0.073 AD 0.240 0.260 AB 1.375 1.395 AG 0.240 0.280 AH 0.240 0.260		0	3.869	3.879	•	3874	3.874	3.874			
R 0.240 0.260		Р	0.115	0.135		124	.124	.124			
R 0.240 0.260	•	Q	0.115	0.135		1378	,130	-130	130		
S 0.115 0.135 T 0.178 0.198 U 2.940 2.980 P 0.230 0.250 P 0.115 0.135 P 0.115 0.135 P 0.115 0.135 P 0.230 0.250 P 0.115 0.135 P 0.240 0.260 P 0.240 0.260 P 0.115 0.135 P		R	0.240	0.260		-251	-251	·2852	251		
U 2.940 2.980	7	S	0.115	0.135		./30			131		
V 0.230 0.250 W 0.115 0.135 X 0.307 0.312 Y 0.760 0.765 Z 0.352 0.372 AA 0.470 0.530 AB 0.615 0.635 AC 0.053 0.073 AD 0.240 0.260 AF 0.115 0.135 AF 0.115 0.135 AG 0.240 0.280 AH 0.240 0.260 AH 0.240 0.260 AH 0.240 0.260 AH 0.240 0.280 AH 0.240 0.260 AH 0.240 0.280 AH 0.240 0.260		Τ .	0.178			188			188		
W 0.115 0.135	[U	2.940	2.980		2,961	2.962		2.961		
X 0.307 0.312 37/ <td< td=""><td></td><td>V</td><td>0.230</td><td></td><td></td><td>272</td><td>243</td><td>246</td><td>-243</td><td></td><td></td></td<>		V	0.230			272	243	246	-243		
Y 0.760 0.765 762 762 762 762 762 762 762 762 762 762 762 762 762 762 762 762 762 762 762 763 <td< td=""><td></td><td>W</td><td>0.115</td><td></td><td></td><td></td><td>.129</td><td>1/27</td><td>,723</td><td></td><td></td></td<>		W	0.115				.129	1/27	,723		
Y 0.760 0.765 762 762 762 762 762 762 762 762 762 762 762 762 762 762 762 762 762 762 762 763 <td< td=""><td></td><td>X</td><td>0.307</td><td>0.312</td><td></td><td>.311</td><td>-310</td><td>-31/</td><td>-3//</td><td></td><td></td></td<>		X	0.307	0.312		.311	-310	-31/	-3//		
Z 0.352 0.372 355 363 <td< td=""><td>, i</td><td>Υ</td><td>0.760</td><td>0.765</td><td>· · · · · · · · · · · · · · · · · · ·</td><td>1762</td><td>.762</td><td>,262</td><td>-762</td><td></td><td></td></td<>	, i	Υ	0.760	0.765	· · · · · · · · · · · · · · · · · · ·	1762	.762	,262	-762		
AB 0.615 0.635		Z,	0.352	0.372	,	.355		.363	-362		
AC 0.053 0.073	Ī	AA	0.470	0.530		. 800	G.	30P)	-300		
AC 0.053 0.073	Ī	AB	0.615			,630		-630	- G3A		
AE 1.375 1.395 1.386 1.3	,	AC	0.053	0.073		~063		.063	-063		
AF 0.115 0.135	Ţ	AD	0.240	0.260	-	257	·232				
AF 0.115 0.135	• 1	AE	1.375	1.395		1.386	1385	1386	1.386		
AH 0.240 0.260 -252 -254 -25/ -25/ AI 2.000 2.020 2.00	, [AF	0.115			-135	-135		./35		
AH 0.240 0.260 -252 -254 .25/ .25/ AI 2.000 2.020 2.00	أحسر	AG	0.240			255	-253				
AJ 0.023 0.043 033 033 033	- '	AH	0.240	0.260		-252	-254				
AJ 0.023 0.043 033 033 033	Ī	ΑI	2.000			2.002	2,007	2-007	2002		
Accept/Reject		AJ			-		-035	E 80.			
	. [Acc	cept/Reje	ct	•		,			•

Measured by:	Audited by 3.L
Date: 0101.10	Date: 07/07//3

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF ,	
В	02.09.24	Re-format; Added Rev. D	KJ	
С	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension Al	KJ/RF , ,	-1
E	05.12.05	Added dimension AJ	KJ/JLM 🚓	911



15.000